

Work Order ID 151722

Friday, October 07, 2016 2:33:35 PM

151722

Page 1

Item ID: D3564-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center

Start Date: 10/3/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: VS (Signature) Date: 10/10/16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3564	Rev D

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.16

FLOW CNC Waterjet

1-Cut as per Dwg D3564

Dwg Rev: DProg Rev: D

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.02				<u>6</u>			DAS 38 9-89 OCT 17 2016
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155Form Joggle as per Dwg D3564 on brake using Jig DT8157	0.01 0.02			DAS 30 9-89	<u>6</u>			NOV 01 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg	0.00 0.02				<u>6</u>			DAS 38 9-89 NOV 02 2016

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Item ID: D3564-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 10/3/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180							DAS 21 9-89	NOV 07 2016	
QC	Memo	0.10							
Quality Control									

DAS
21
9-89

NOV 03 2016

Picklist Print

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Work Order ID: 151722

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Parent Item: D3564-5

D3564-5

Parent Item Name: Wearplate Center

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	113.4000	1.5	9.473684			

M304S16GA

304/316 Sheet .063

De 16/10/14

Location

Loc Qty

Loc Code

MAT010

113.4

m135377

46.8

m135559

2.6

m135689

64

7

DART AEROSPACE LTD		Work Order: 151722
Description: Wearshoe		Part Number: D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1

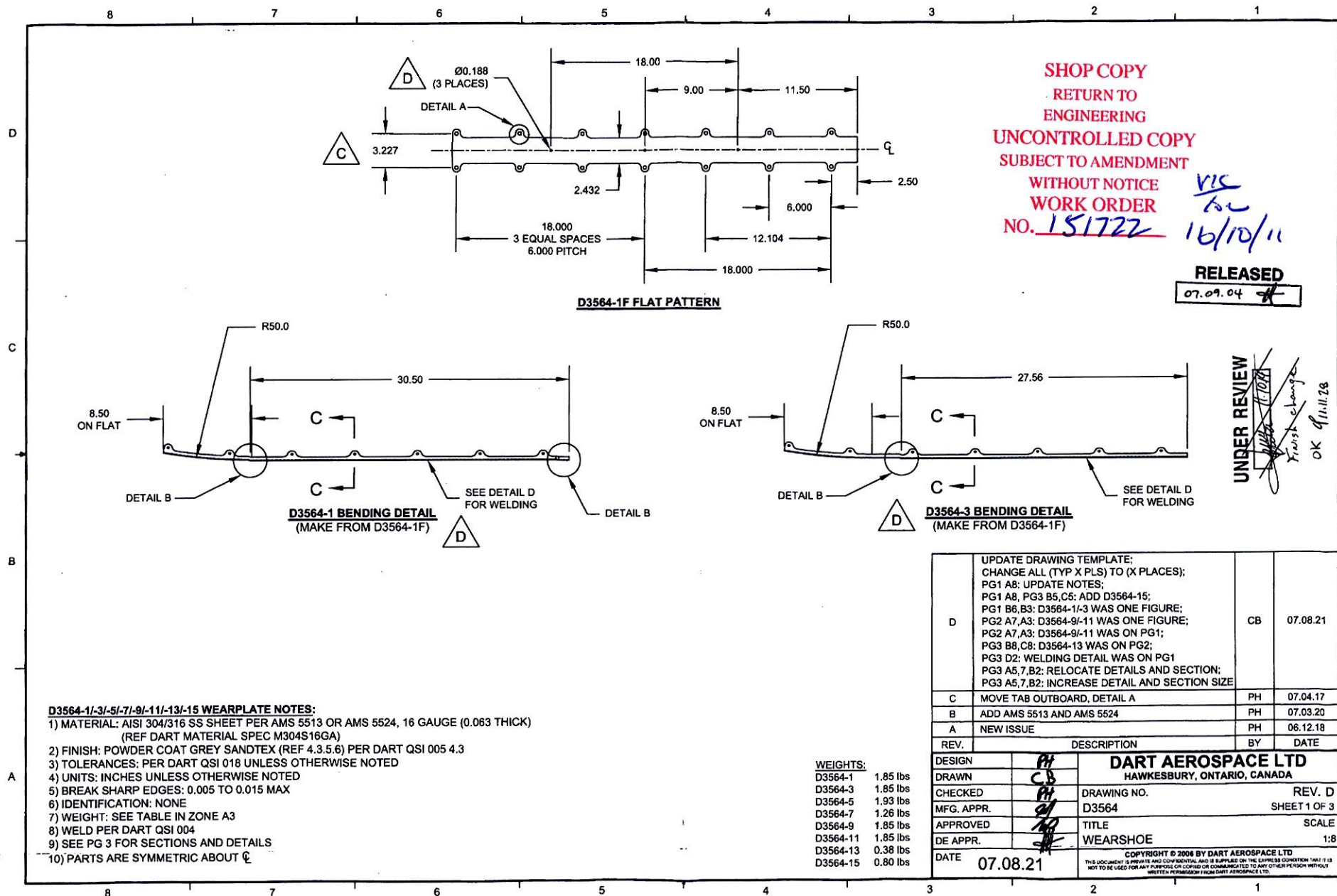
FIRST ARTICLE INSPECTION CHECKLIST

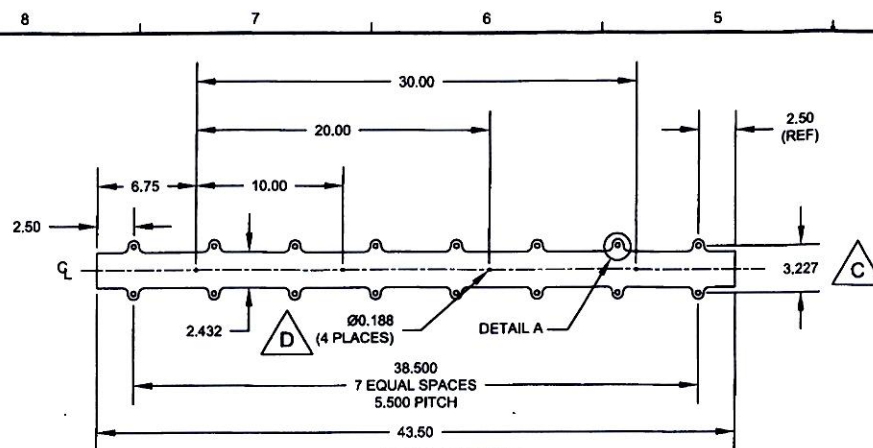
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	1		V: 0.02	
6.75	+/-0.030	6.75	1		Tap	
10.00	+/-0.030	10.00	1			
20.00	+/-0.030	20.00	1			
30.00	+/-0.030	30.00	1			
2.50	+/-0.030	2.50	1			
3.227	+/-0.010	3.226	1			
38.500	+/-0.010	38.500	1			
5.500	+/-0.010	5.502	1			
2.50	+/-0.030	2.50	1			
2.432	+/-0.010	2.438	1			
0.300 x 0.300	+/-0.010	302x.904	1			
Ø0.188	+0.005/-0.001	Ø.190	1			
R0.375	+/-0.010	.375	1			
0.063	+/-0.010	.057	1			

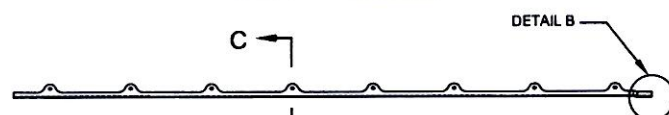
Measured by: de	Audited by: DAS 38	Prototype Approval: N/A
Date: 11/10/14	Date: OCT 17 2016	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DS

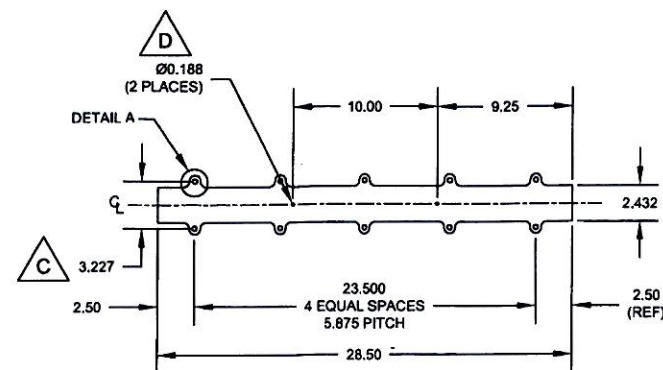
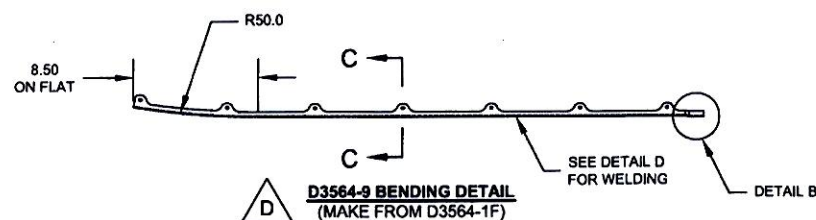




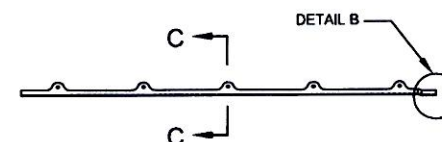
D3564-5F FLAT PATTERN



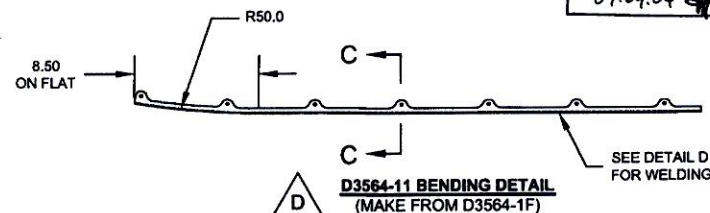
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

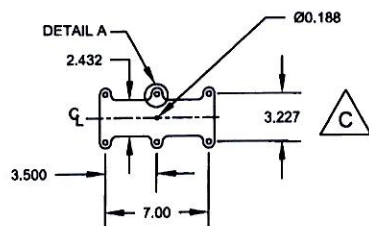


UNDER REVIEW
OK QP L.L.L. Z8

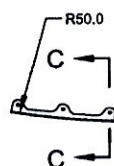
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
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DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

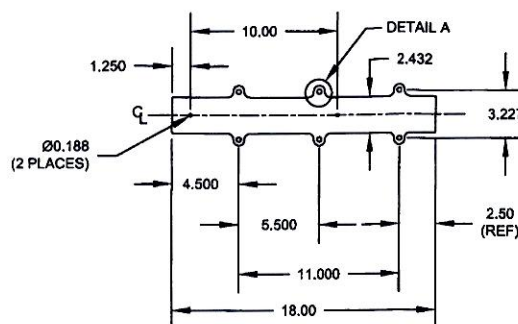
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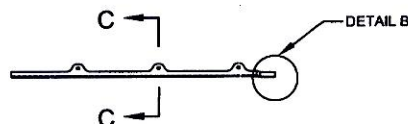
D3564-13F FLAT PATTERN



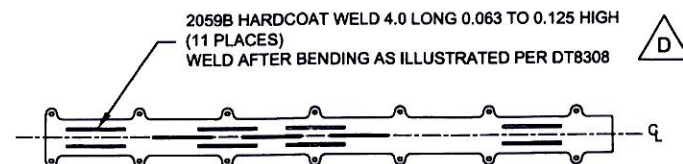
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



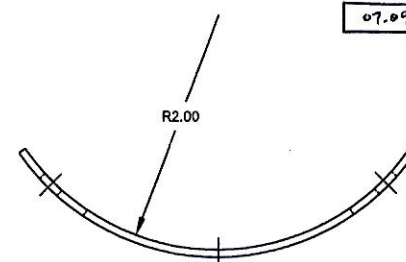
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

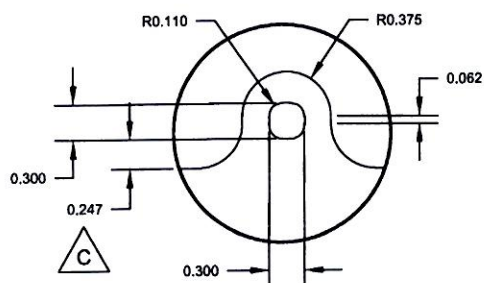
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07.09.04

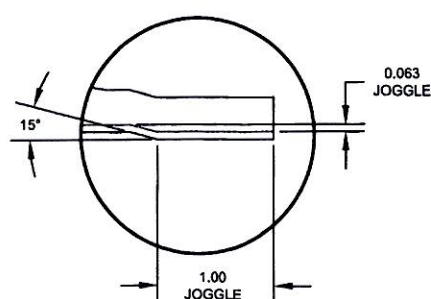


SECTION C-C
SCALE 1:1

UNDER REVIEW
OK 07.11.28



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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8 7 6 5 4 3 2 1